

Date: Wednesday, 9/12/2007 12:14:17 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WHEEL ASSEMBLY
Job Number : 34623	
Estimate Number : 12100	
P.O. Number : <i>N/A</i>	Part Number : D3397041
This Issue : 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3397 REV.A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 30391	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/19/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev. <i>A</i> new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3397041	wheel ass'y
-----	----------	-------------



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
 wheel ass'y

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting PURCHASING  
 Issue P/O: *4577*

Order Part #4997T28 from McMaster-Carr as per DwgD3397  
 Ensure Certificate of Conformity is attached

*U 07-09-13 12*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure certificate of conformity is attached

*ES 07/09/14 (12)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK  
 Ensure certification comply to Dwg D3397

*409-17 (12)*

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Remove retainers and bearing from wheel, do not damage retainers, discard bearing.

2-Ship retainers to machining

*CP 07-09-18 (12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:14:17 PM  
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## Process Sheet

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Drawing Name: WHEEL ASSEMBLY

Job Number: 34623

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE  
1-Turn as per Dwg D3397

2-Deburr  
IDENTIFY AS D3397-3

*20 01/01/19*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*22 07/07/09-20*

8.0

D33975

sleeve



Comment: Qty.: 1.0000 (s)/Unit Total: 12.0000 (s)

Pick:

Qty Part number Description  
1 D3397-5 sleeve

batch

*B34638 → 11 ✓*  
*B30585 → 1 ✓*

*07.09.24*

9.0

HK2820

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part number Description  
2 HK2820 bearing

batch

*M105715 → 8*  
*M103488 → 10*

*07.09.24*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Assemble bearing, sleeve and retainers as per dwg D3397

*07.09.24*

*(12)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/09/24*

*center*

*(12)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PKG 07.09.24*

*(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/6/25

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 9/12/2007 12:14:17 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 34623

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

27/9/05

Job Completion



U 27/9/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

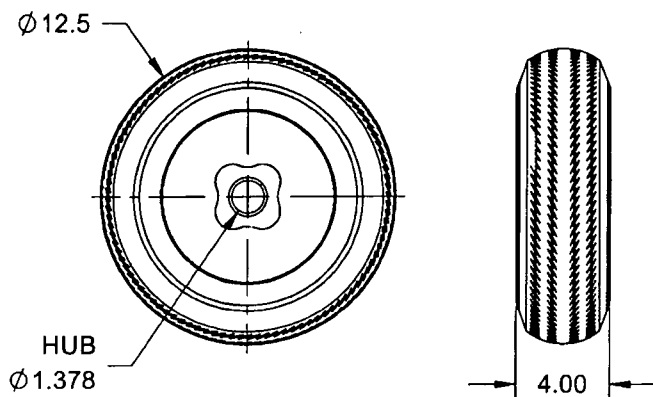
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





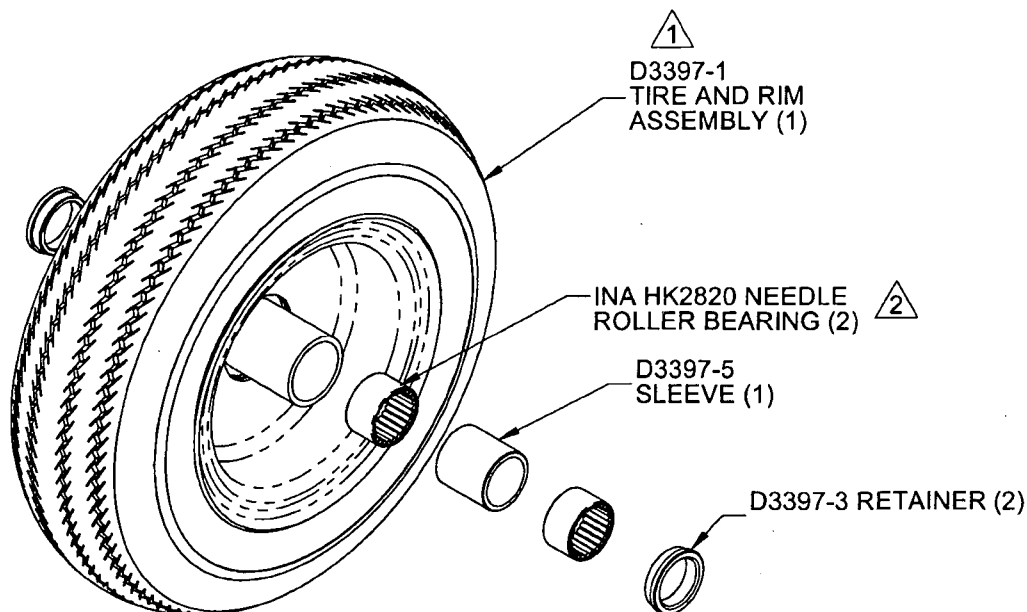
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3397	REV. A SHEET 1 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:8
A	05.02.10	NEW ISSUE	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: $\phi 12.4 \times 4.1$ RIM: $\phi 6.0 \times 4.0$	445 LBS	50 PSI*

**1 D3397-1 TIRE AND RIM ASS'Y**

RELEASED  
06/03/07



**D3397-041 WHEEL ASS'Y**

**NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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WORK ORDER  
34623

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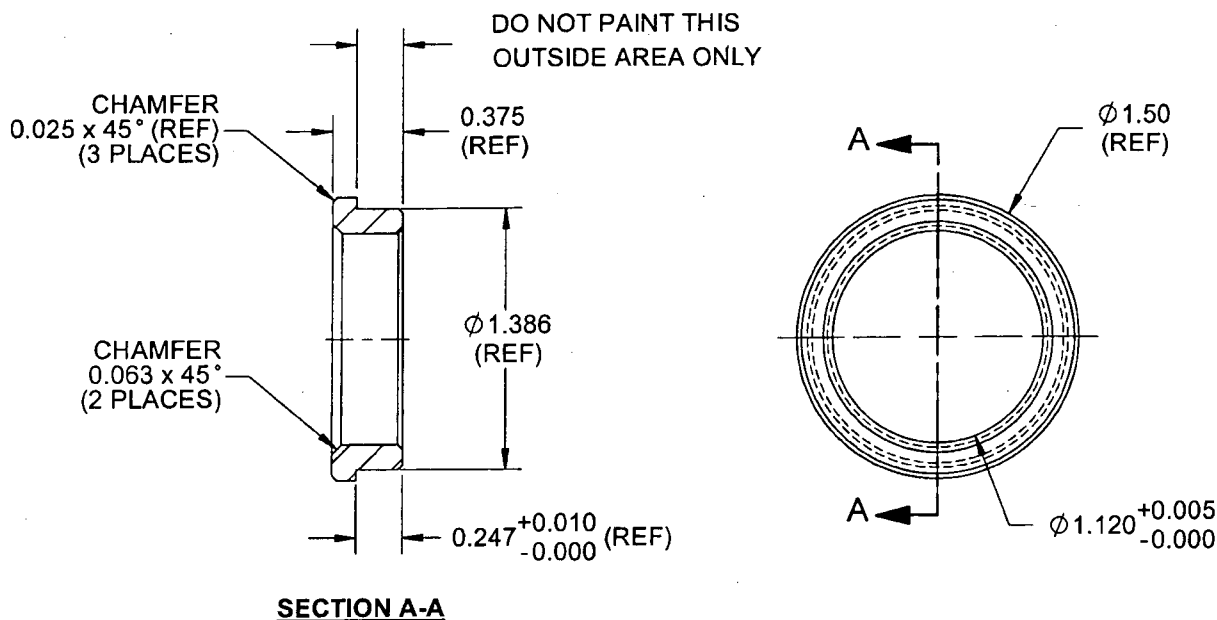




DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 2 OF 3
DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED  
06/23/09

## SPECIFICATION CONTROL DRAWING



### D3397-3 RETAINER

#### NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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WORK ORDER  
NO. 34623

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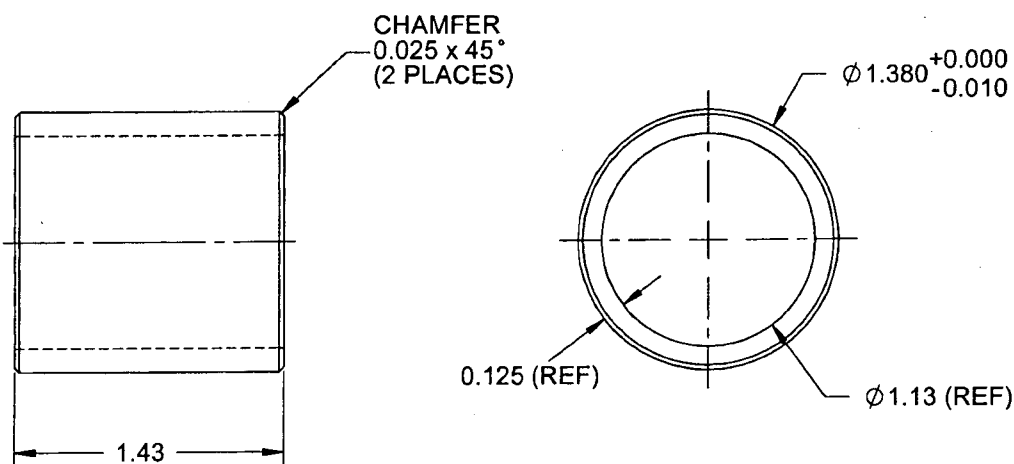
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED  
06/03/09

[Signature]



### D3397-5 SLEEVE

#### NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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NO. 34623

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ROSPACE LTD  
ABERDEEN ST  
KESBJRY  
FINISHED GOODS LOCATION

K6A.1

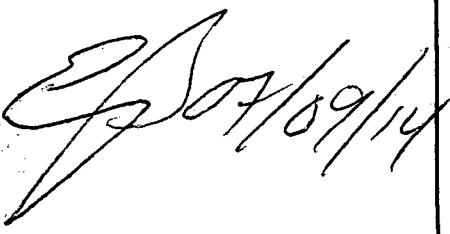
YOUR PURCHASE  
ORDER NUMBER  
P00000

Today's Date: 9/13/07

MCMASTER-CARR  
200 AURORA INDUSTRIAL PKWY.  
AURORA OH 44202

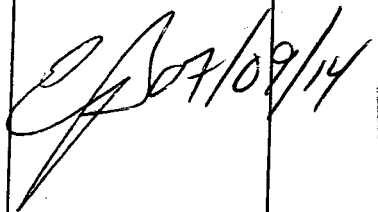
IF THERE ARE ANY QUESTIONS ABOUT THIS  
SHIPMENT, CONTACT OUR SALES DEPARTMENT  
(330) 995-5500

PAGE  
1 OF 1  
MCM NUMBER  
8719065-01

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
8- 97-40 91-24	4997 T28	12 EA	PNEUMATIC WHEEL WITH TWO-PIECE RIM 12.4" x 3.6", CENTER HUB, 1" AXLE, ROLLER BRNG, 440WCAP 98 RAS	2	12 EA	12
	92311 A599	*****	Information about the rest of your order  TYPE 18-8 SS CUP POINT SOCKET SET SCREW Shipped 10 PK today from this McMaster-Carr warehouse	1	10 PK	
	9610 K18		MILITARY SPECIFICATION BRASS GROMMET KIT Shipped 5 EA today from this McMaster-Carr warehouse Balance of 15 EA expected to ship by 9/19/2007	3	20 EA	
						980

Comments: PER DRWG D3619 REV.A  
P/N 9610K18

B34611



CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Comments:

Tax Summary:

Less:	
included tax	0.00
Subtotal	837.60
Total tax	0.00
Total purchase order in	
USD Dollars	837.60

Entered By: LLACELLE

Approved By: 